

Date: Friday, 22/08/2008 2:02:47 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 41605
 Estimate Number : 12428
 P.O. Number :
 This Issue : 22/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D35061
 Drawing Number : D3506 REV A
 Project Number : N/A
 Drawing Revision : A
 First Issue : / / Type : MACHINED PARTS
 Material :
 Previous Run : 28963 Due Date : 02/09/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : JLD 08.8.22
 Comment : Est Rev:A New Issue 06-05-31 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S100 6061-T6 .100 Sheet



Comment: Qty.: 0.0082 sf(s)/Unit Total: 0.0819 sf(s)

6061-T6 .100 Sheet

(M6061T6S0100)

Batch: 102201

IB 8-9-10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3506

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 8-9-10

(15)

D 08/08/11 (15)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-9-10

(15)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA640 and Dwg D3506

DJP 08/09/19

(15)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



DJP 08/09/19

(15)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 41605

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/08/19

(15)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
C'sink as per Dwg D3506(On Flat side)

FF 08/10/01

(15)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/02

(15)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

08-10-02

(15)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/02

(15)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *106*

8/10/02

510

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03

Job Completion



08-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

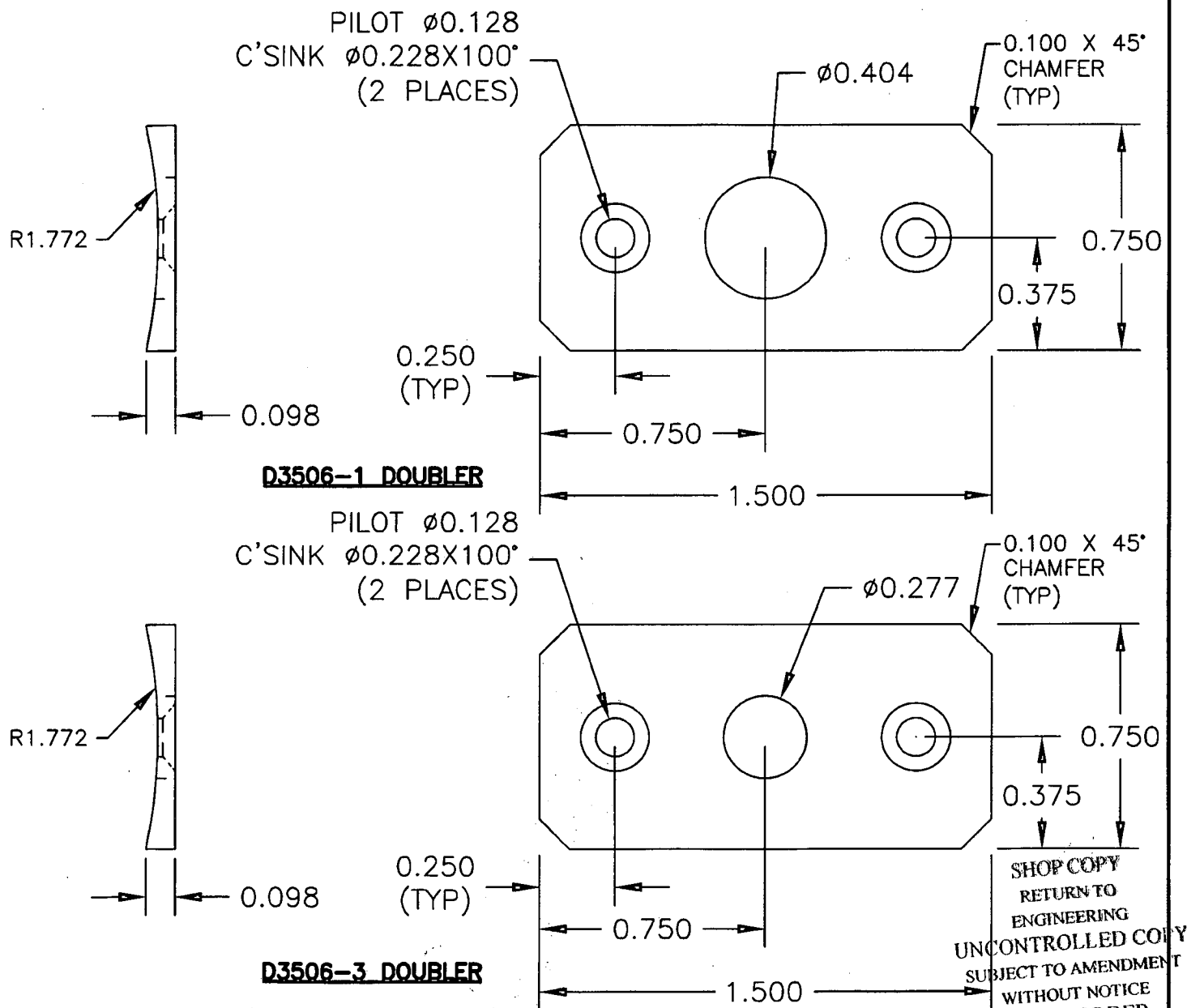
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN HH	DRAWN BY HH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED HH	APPROVED HH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	



D3506-1/-3 DOUBLER

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.03 PM
PER E2N #361

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